

Work Order ID 76470

November-15-11 8:11:50 AM

76470

Page 1

Item ID: D3252-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Large Shelf
 Start Date: 15/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 11/11/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3252	Rev A								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3252 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary -
 2024.063 B12-5-30

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control B12-5-30

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control (S) 12 05 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76470

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/11/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

Bend as per dwg D3252

140

QC5- Inspect part completeness to step on W/O

0,00

140

0.00

QC

Memo

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

0.00

HandFinish

Memo

Hand Finishing

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

76470

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME: _____

OVEN TEMPERATURE:

0.00

2:50

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

180

Identify as per dwg & Stock Location: 81/398 0.00

180

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Work Order ID 76470***76470***

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November-15-11 8:11:50 AM

Item ID: D3252-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Large Shelf

Start Date: 15/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/6/4

MC 12/6/01

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

November-15-11 8:11:54 AM

Page 1

Work Order ID: 76470

76470

Parent Item: D3252-1

D3252-1

Parent Item Name: Large Shelf

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3252-1 no longer made in-house
IPP c 08.11.13 in-house ec verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063		Purchased	No			110	sf	33.5000	2.166	9.12	16 16		
										**			
<div style="display: flex; justify-content: space-between;"> <div> <p>*M2024T3S 063*</p> <p>2024-T3 .063 sheet</p> </div> <div> <p><u>Location</u></p> <p>MAT022</p> <p>117392</p> </div> <div> <p><u>Loc Qty</u></p> <p>33.5</p> <p>33.5</p> </div> <div> <p><u>Loc Code</u></p> <p>119916</p> </div> <div> <p>1317-5-30</p> <p>5</p> </div> </div>													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76470
Description: Large Shelf (Dual Battery Rack)		Part Number: D3252-1
Inspection Dwg: D3252	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.289	+/-0.010	23.289	✓		T	
0.619	+/-0.010	0.616	2		V	
0.300	+/-0.010	0.300	2		V	
10.400	+/-0.010	10.400	2		T	
1.300	+/-0.010	1.306	2		V	
11.638	+/-0.010	11.632	2		T	
R0.19	+/-0.030	0.19	✓		R.G.	
R0.13	+/-0.030	0.13	✓		R.G.	
0.697	+/-0.010	0.700	2		V	
21.863	+/-0.010	21.863	✓		T	
R0.30	+/-0.030	0.30	✓		R.G.	
12.334	+/-0.010	12.337	2		T	
Grain along 23.289	N/A		✓		EYES	

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12-5-30	Date: 12.05.30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	[Signature]

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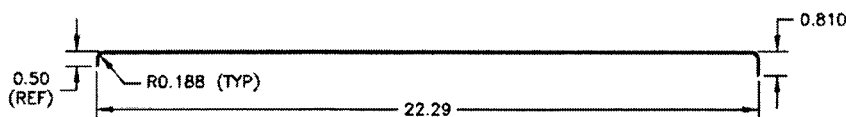
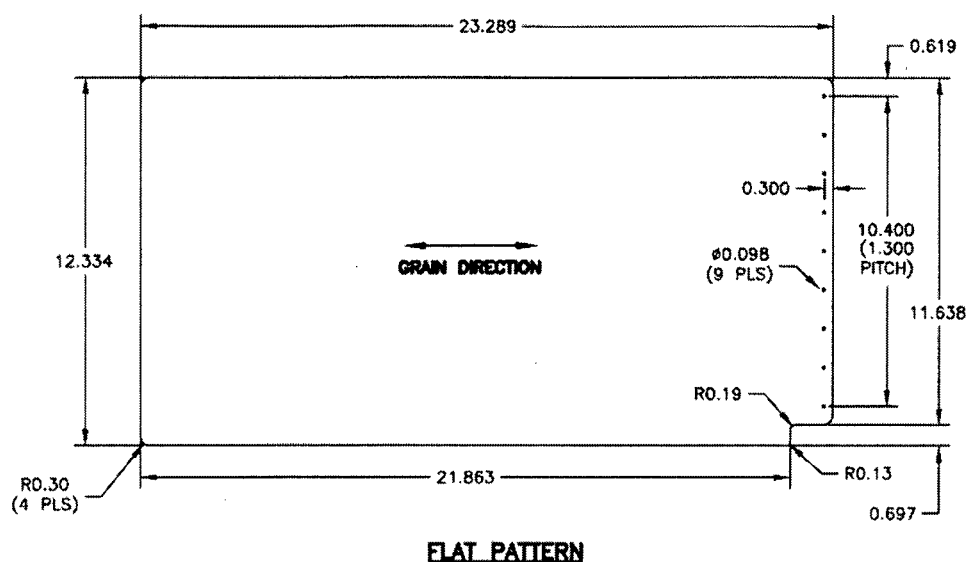
NOTE: Date & initial all entries



DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>RT</i>	DRAWING NO. D3252	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE LARGE SHELF (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

RELEASED
04.05.04

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO - 70470
M.L.J
11/11/15



NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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